

Date: Tuesday, 02/06/2009 11:30:54 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BASKET LID ASSEMBLY
Job Number : 48311C	
Estimate Number : 10212	
P.O. Number :	Part Number : D3267041
This Issue : 02/06/2009 S.O. No. :	Drawing Number : D3267 REVC
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : LARGE FAB ASSY	Drawing Revision : C
Previous Run : 36603C	Material :
Written By :	Due Date : 10/06/2009 Qty: 1 Um: Each
Checked & Approved By : <u>JUD 09.06.08</u>	
Comment : Est Rev:C Removed -043 05-11-04 JLM Est Rev:D 08-09-10 revC as per dwg (ecn 08-524) DD verified by:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TS0750W065	304 SQ Tube .75x.75x.065W
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Comment: Qty.: 32.1300 f(s)/Unit Total : 32.1300 f(s)
 3/4" x 3/4" x 0.065" wall 304/316 SS tubing
 Batch: M 111825

SAP 09-06-15 (1)

2.0	D31663	Basket Hoop
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Qty 1 D3166-3 Basket Hoop
 Batch: 44997 (0.200) 46629 (65806)

SAP 09-06-11 (1)

3.0	D23273	Spacer Bushing
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Pick:
 Qty Part number Description Batch
 2 D2327-3 Bushing B44274

PD 09.06.17

4.0	D2506	Label Plate
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Pick:
 Qty Part number Description Batch
 1 D2506 Label Plate B45735

PD 09.06.17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:

Machine Or Operation:

Description :

5.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number

Description

Batch

2 D2581

Mounting Brackets

B47264

PD 09-06-17

6.0

M304EX07516F

Expanded Metal Flat SS



Comment: Qty.: 8.1900 sf(s)/Unit Total : 8.1900 sf(s)

Pick:

Qty Part number

Description

Batch

7.8sf

M304EX0.75-16F Expanded Metal

M111630

SAD 09-06-15

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut Rib from 3/4" x 3/4" x 0.063" wall 304/316 SS tubing as per Dwg D3267

2-Cut (4) D2236-1 From D3166-3

3-Drill holes in tubing D3267-041 as per Dwg D3267

4-Deburr & Remove All Markings From Material

5-Weld D3267-041 Assembly using Welding Table and corner Jig as per Dwg D3267. Deburr as required

Note: Expanded metal "diamonds" must run lengthwise. Eg 2.0" along length of lid.

6-Drill Ø0.257" hole in D3267-041 as per Dwg D3267 Identify as D3267-041

PD 09-06-17

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

6/09-06-17

9.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

5 09/06/17 (H)

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Seq. #:

Machine Or Operation:

Description :

10.0

POWDER COATING

POWDER COATING



M111472



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

PRESSURE WASH 09-06-12

1ST COAT

START TIME:

1:30pm

OVEN TEMPERATURE:

400°F

FINISH TIME:

2:00pm

***** 2nd coat if necessary *****

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

ell

09-06-12

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing walk as per Dwg D3267 and QSI 005 4.4

Spray Paint Black:

M111310

Wing Walk:

M111013

UMD/BR 09/06/18

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat and Wing Walk

509/06/18

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/19

Job Completion



MF
09-06-19

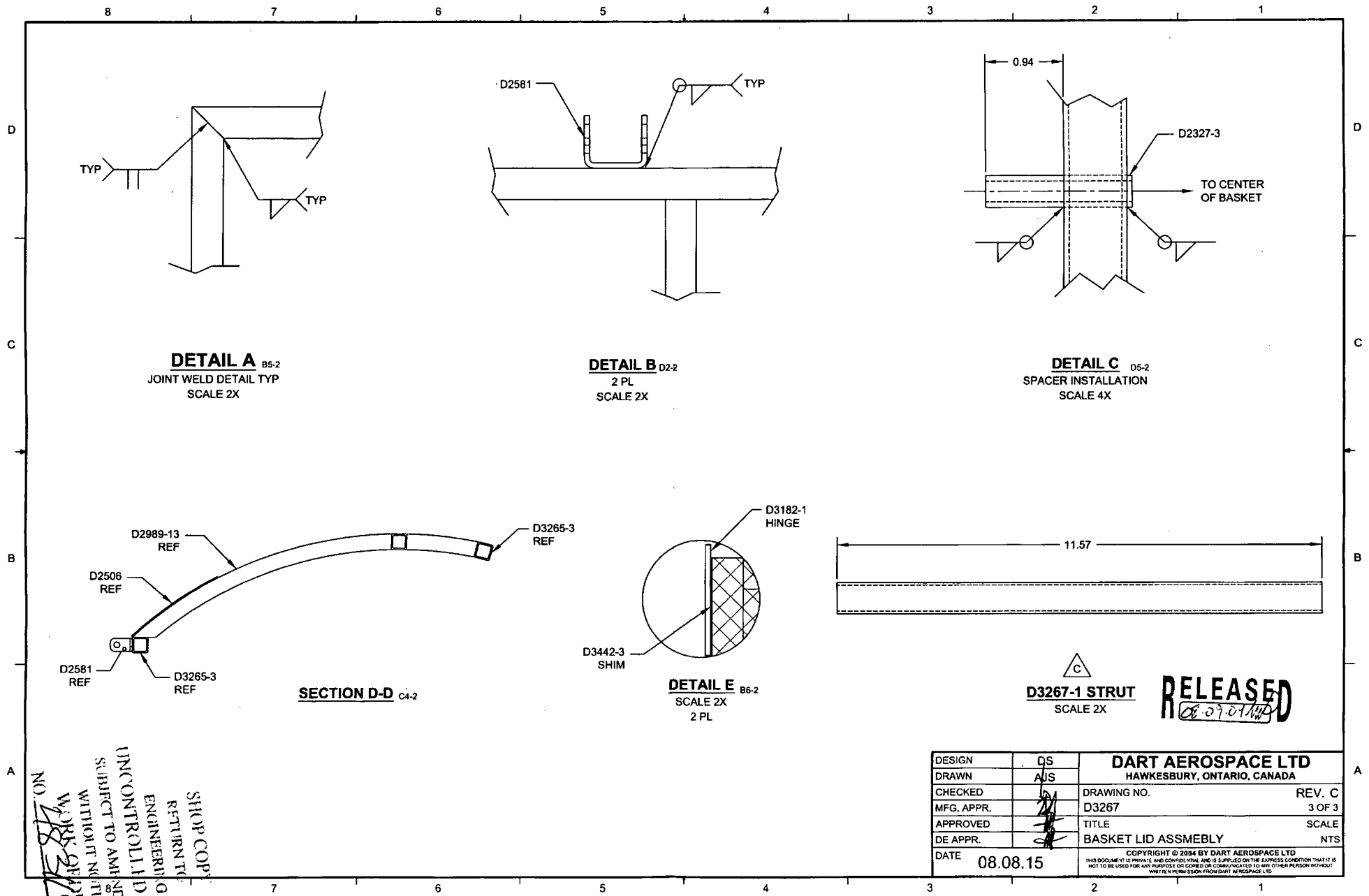
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



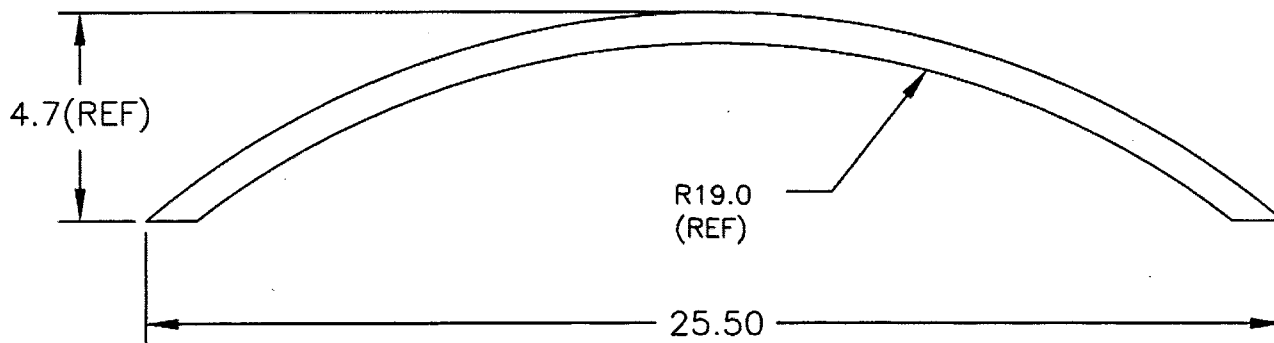
NO. 178-217
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DESIGN BW	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D2236	REV. C SHEET 1 OF 1
DATE 05.06.07		TITLE LID RIB	SCALE 1:4
A	94.05.30	NEW ISSUE	
B	94.12.16	LID	
C	05.06.07	UPDATE NOTES, CHANGE RADIUS TO 19.0	

RELEASED

05-08-19 H



D2236

D2236 LID RIB

- 1) MAKE FROM D3166-3 BASKET HOOP
- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES AER PER DART QSI 018 UNLESS OTHERWISE NOTED

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